

Date: Wednesday, 24/09/2008 12:47:51 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HYDRAULIC CYLINDER
Job Number :	42266		
Estimate Number :	12750		
P.O. Number :		Part Number :	41232 200 007 001
This Issue :	24/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	41232-200-007 REV IR
First Issue :	//	Project Number :	N/A
Previous Run :	39219	Drawing Revision :	IR
	Type :	Material :	
	PURCHASED PARTS	Due Date :	20/10/2008
Written By :		Qty:	19/4 Um: Each
Checked & Approved By :	JUD 08.9.24		
Comment :	Est Rev:A New Issue 07-02-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	7D 1 H	Clippard Brass Cylinder
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Spring (Step Actuator)

2.0	PG	PURCHASING
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Comment: PURCHASING
 Issue P/O: 7244
 Possible Supplier: Wainbee
 Material release note is required

C208/09/25

(10)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

R 8/10/15 (10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

808/10/17 (10)

5.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING
 Mask threaded ends and threaded holes.
 1-Apply polyimide primer
 Batch: 109 278
 2-Apply polyurathane coating gloss black
 Batch: 109 278

}

21

08-10-29

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 12:47:51 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HYDRAULIC CYLINDER

Job Number: 42266

Part Number: 41232 200 007 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

Note: Paint Nut on threaded end and leave attached to assembly

08-10-29 (10)

6.0

QC14

INSPECT SPRAY PAINT



08/10/29

(10)



Comment: Inspect Spray Paint

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Install Decal then
Identify and Stock
Location: 267

8/10/29

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/31

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

ON
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

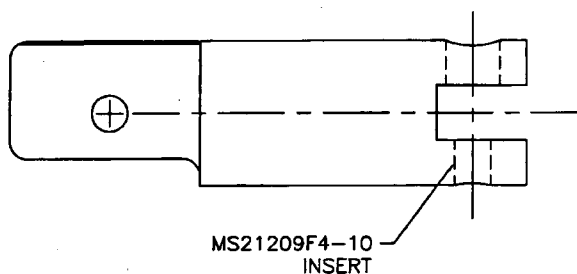
IS

1	MS21209F4-10	INSERT
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WAS

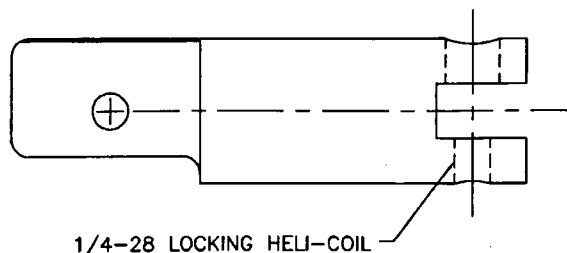
1	MS21209F4-15	INSERT
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IS



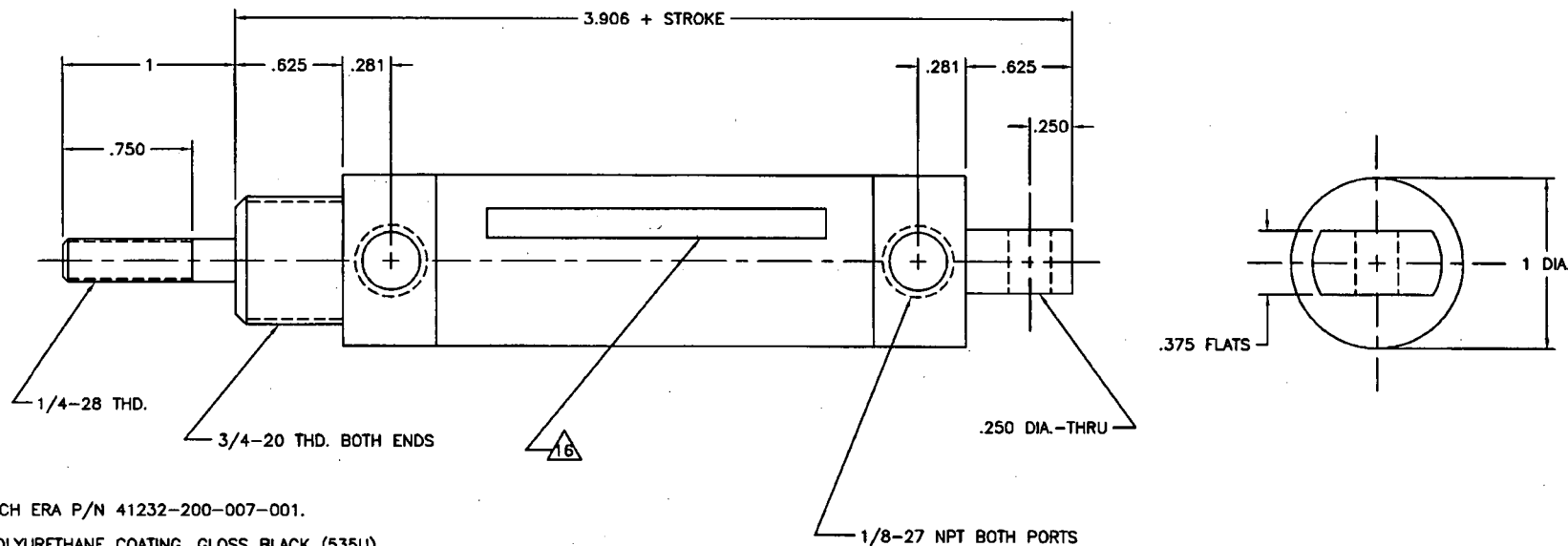
-005 PIVOT ARM

WAS



-005 PIVOT ARM

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				



- △ VIBRO ETCH ERA P/N 41232-200-007-001.
15. APPLY POLYURETHANE COATING, GLOSS BLACK (535U) IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4009.
 14. APPLY POLYIMIDE PRIMER IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4004.
 13. PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

NOTE - ALTER 7D1H ASSY IN ACCORDANCE WITH INSTRUCTIONS LISTED ABOVE.

-001 BRASS CYLINDER

12. SINTERED BRONZE ROD BUSHING.
11. ROD DIAMETER: 0.25 INCHES.
10. PORTS: 1/8 NPT.
9. POWER FACTOR: 0.6 SQ. IN.
8. STROKE: 1.000 INCH.
7. ACTION: DOUBLE ACTING.
6. MOUNT: UNIVERSAL MOUNT.
5. TEMPERATURE RANGE: 30° F TO 230° F.
4. 7D1H CONFIGURED WITH HYD. FLUID SEAL.
3. ROD: ROTATING.
2. BORE: 0.875 INCHES.
1. HEAVY DUTY BRASS CYLINDERS.

NOTES:

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 4226

-001		BRASS CYLINDER 7D1H		CLIPPARD INSTRUMENT LABORATORY, INC., CINCINNATI, OH.			
PART NO.		NAME		STOCK SIZE	MATERIAL	MATL.SPEC	ZONE
NO. REQ'D PER ASSY		LIST OF MATERIAL					
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED		DRFTSMAN	D. NELSON	3/14/03	TITLE
THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. NO DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORWARDED WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		X ± .1		CHECK	D. MURPHY	3/14/03	HYDRAULIC CYLINDER (ALTERED ITEM DRAWING)
		XX ± .03		STRESS			
		XXX ± .010		PROL. ENGR.			DWG. SIZE
		ANGLES ± 1/2°		HEAT TREAT			C
				FINISH	Era Aviation, Inc.		SCALE
							NONE
-001 2 41232-000-001		NEXT ASSEMBLY		DWG. NO.		41232-200-007	REV.
							IR




WAINBEE LIMITED
215 BOUL BRUNSWICK
POINTE CLAIRE, PQ H9R 4R7
Phone: 514-697-8810 Fax: 514-697-3070

Packing List

CUSTOMER P/O NUMBER	
:PO00007244	
RELEASE #	15017389-1
DATE	10/14/08 09:46:51

127404
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
613-632-3336

SHIP TO
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

ORDER NUMBER 15017389	ORDER DATE 09/25/08	SHIP DATE 10/14/08	WRITTEN BY Hugues Roy		CONTACT CHANTAL LAVOIE(t)		
CUSTOMER P/O NUMBER :PO00007244							
JOB #							
RELEASE #							
PRODUCT / DESCRIPTION			QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE /EXTENSION
7D-1-H			10	EA	10	0	80.440
CLIPPARD BRASS CYLINDER							804.40

S
09/25/08

Wainbee's Standard Terms and Conditions Apply

Returned Goods Not Accepted Without Prior Authorization.

Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.